

## CLAIMS

We claim:

1. A mop head comprising:  
at least two cords, aranged side-by-side and generally parallel to one another defining a layer of cords, wherein at least one cord is formed by twisting at least two filaments together, the filaments being less than 1 denier.
2. The mop head of claim 1, wherein the cords are looped.
3. The mop head of claim 2, wherein the looped end of each cord is secured to a common surface.
4. The mop head of claim 1, wherein at least one cord is at least 1,000 denier.
5. The mop head of claim 1, wherein at least one cord is from about 1,000 denier to about 25,000 denier.
6. The mop head of claim 1, wherein the filaments are between about 0.02 denier and about 0.99 denier.
7. The mop head of claim 1, wherein at least one filament is a polyester material.
8. The mop head of claim 1, wherein at least one filament is a nylon material.
9. The mop head of claim 1, wherein at least one filament is a combination of a polyester material and a nylon material.
10. A mop head comprising:  
at least two cords aranged side-by-side and generally parallel to one another defining a layer of cords, wherein the cords are formed by intertwining at least two filaments together, the filaments are split to comprise a core member, a plurality of projections emanating from the core member, and a wedge-shaped insert disposed between every other projection.
11. The mop head of claim 10, wherein the cords are looped.
12. The mop head of claim 10, wherein at least one cord is at least 1,000 denier.
13. The mop head of claim 10, wherein the cords are from about 1,000 denier to about 25,000 denier.
14. The mop head of claim 10, wherein the filaments are between about 0.02 denier and about 0.99 denier.

15. The mop head of claim 10, wherein at least one filament is a polyester material.
16. The mop head of claim 10, wherein at least one filament is a nylon material.
17. The mop head of claim 10, wherein at least one filament is a combination of a polyester material and a nylon material.
18. A mop head comprising:  
at least two strips of a cloth material aranged side-by-side and generally parallel to one another defining a layer of strips, the cloth material woven from filaments having a denier of less than 1.
19. The mop head of claim 18, wherein the filaments are about 0.02 denier to about 0.99 denier.
20. The mop head of claim 18, wherein the strips are ultrasonically cut from larger sheets of stock material.
21. The mop head of claim 18, wherein at least one strip has a width from about 0.10 cm to about 30 cm.
22. The mop head of claim 18, wherein at least one filament is a polyester material.
23. The mop head of claim 18, wherein at least one filament is a nylon material.
24. The mop head of claim 18, wherein at least one filament is a combination of a polyester material and a nylon material.
25. A method of making a mop head comprising:  
providing a precursor material;  
spin-extruding said precursor material to form a precursor filament;  
treating the precursor material to form a filament, wherein the filament is less than 1 denier; and  
interwinning at least two filaments together into a bundle to form a cord.
26. The method of claim 25, wherein the precursor material is a polyester material.
27. The method of claim 25, wherein the precursor material is a nylon material.
28. The method of claim 25, wherein the precursor material is a combination of a polyester and a nylon material.
29. The method of claim 25, wherein the filament is from about 0.02 to about 0.99 denier.

30. The method of claim 25, wherein about 2 to about 1,250,000 filaments are intertwined together into a bundle to form a cord.